

Date: Monday, 11/14/2005 2:28:38 PM
 User: Linda Lacelle

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 206 L HIGH GEAR SKIDTUBE |
| Job Number | : 24764 | | |
| Estimate Number | : 10539 | | |
| P.O. Number | : N/A | Part Number | : D206642341 |
| This Issue | : 11/14/2005 S.O. No. : N/A | Drawing Number | : D2650 REV D1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : LANDING GEAR | Drawing Revision | : D1 |
| Previous Run | : 24662 | Material | : N/A |
| Written By | : SEE COMMENT BELOW | Due Date | : 11/30/2005 Qty: 1 Um: Each |
| Checked & Approved By | : SEE ABOVE WORK & DATE | | |
| Comment | : Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM | | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341CHG002

REC'D p/wad 10/10/03/23 (CZ)
 DH

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD

B24497 DP 05-12-15 ①

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap

B220535 ①

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

DP 05-12-15 ①

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

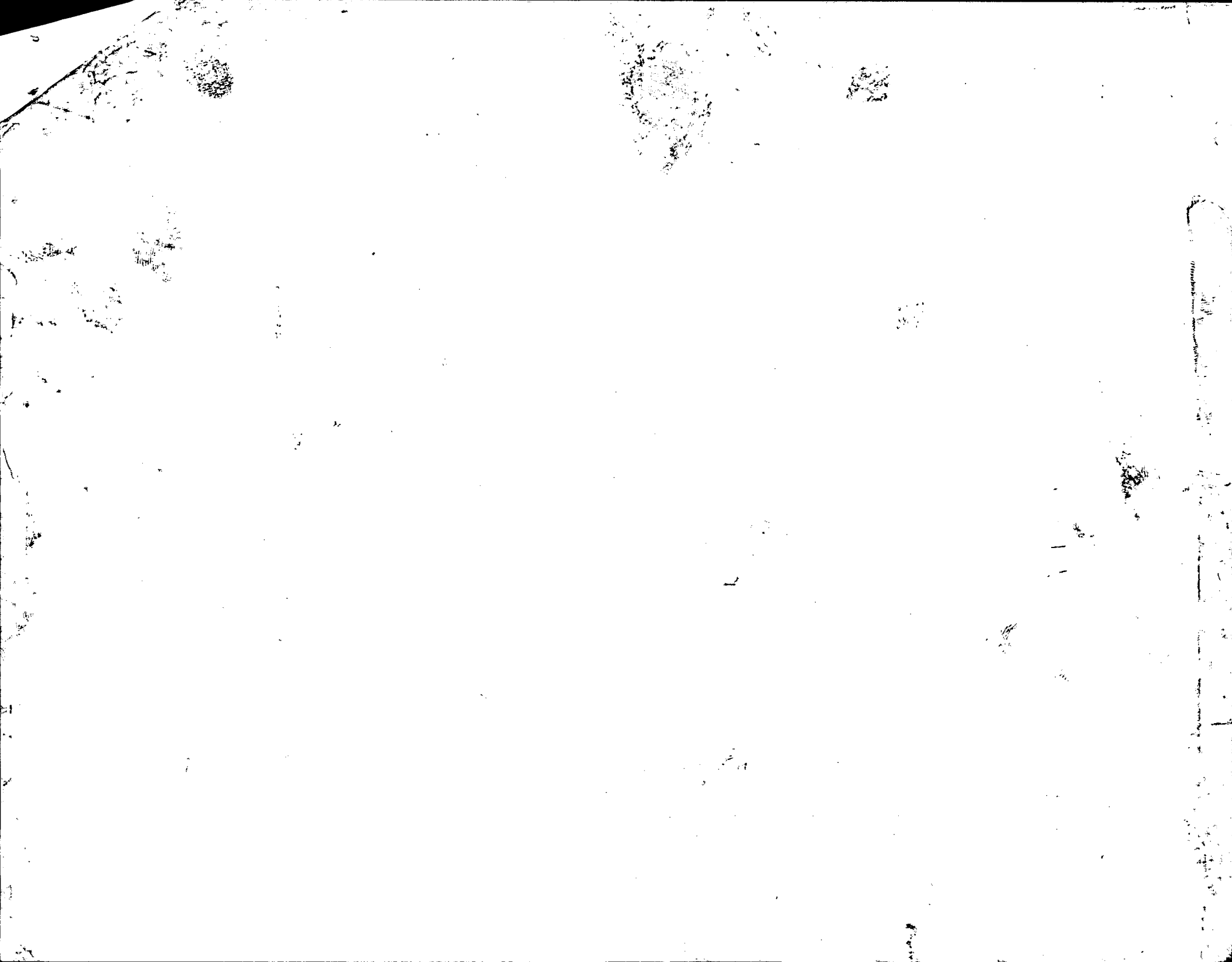
DP 05-12-15 ①

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M15855/M18901 BE 05-12-19 ①

4-Grind weld flush to cap on top surface only.

BE 05-12-19 ①



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Part Number: D206642341

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

5-Cut aft end 117.350" from front of tube *DP05-12-22 ①*

6-Drill pilot holes using drill Jig DT8168A (A,B & C) *DI 8025+* Open to Ø0.312" *As per DWG 2650-5 Pm' 06-01-03 ①*

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297" *DT 8028-5 Pm' 06-01-03 ①*

8-Open using #6 Drill Bit *AFT CAP hole Pm' 06-01-03*

9-Open holes for Tow Ring to Ø0.640" as per Dwg D2650, D2650-5 Drilling Detail *06-01-03 Pm' 06-01-03*

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650 *Pm' 06-01-03*

11-Deburr and Blow out all chips from inside the tube *Pm' 06-01-03*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *a.m 06-01-10 ①*

6.0

D26545

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-5

Web

B2093 a.m 06-01-13 ①

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) *Pm' 06-01-11 ①*

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid) *a.m 06-01-11 ①*

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. *a.m 06-01-11 ①*

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: *06-01-13* Time: *10:00*

Finish Date: *06-01-18* Time: *1:00 P*

A/R Sikaflex-291 *M19134*

Sikaflex expiry date: *06-06-20 a.m 06-01-13 ① a.m 06-01-14 ①*

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Part Number: D206642341

Job Number:



Seq. #: Machine Or Operation: Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



06-01-17

Comment: INSPECT WORK TO CURRENT STEP

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 D2649 Crossbolt spacer

B24200 BE 06-01-18 (1)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod *M15255 BE 06-01-18 (1)*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

BE 06-01-19 (1)

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

BE 06-01-19 (1)

11.0

D2682041

Support Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate

B21103 BE 06-01-19 (1)

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS33

Rivets

M18548 BE 06-01-19 (1)

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Part Number: D206642341

Job Number:



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|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|----------|-------|
| 13.0 | M7885343 | Rivet |
|------|----------|-------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets

m 7808 BE 06-01-19 (1)

| | | |
|------|-----------------|----------------------------|
| 14.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

BE 06-01-19 (1)

| | | |
|------|-------|-----------------|
| 15.0 | QC5/9 | WELD INSPECTION |
|------|-------|-----------------|



Comment: WELD INSPECTION

J-06-01-22 PD 06-01-25

| | | |
|------|----------------|----------------|
| 16.0 | POWDER COATING | POWDER COATING |
|------|----------------|----------------|



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

DL 06/03/14

(1)

| | | |
|------|-----|---|
| 17.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|------|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

| | | |
|------|--------|---------|
| 18.0 | D26483 | Wearpad |
|------|--------|---------|



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B 24843

(6)

| | | |
|------|---------|-----------|
| 19.0 | D265611 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-11

Wearshoe

B 116357

(1)

Q. m 06-03-22

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Job Number: 24764

Part Number: D206642341

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------|-----------|
| 20.0 | D265623 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-23 Wearshoe B2109C

(1)

| | | |
|------|---------|-----------|
| 21.0 | D265635 | Wearplate |
|------|---------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2656-35 Wearshoe B 24148

(1)

| | | |
|------|--------|---------|
| 22.0 | D34291 | WEARPAD |
|------|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3429-1 Wearpad B 24417

(1)

| | | |
|------|-------------|--------|
| 23.0 | ALS41032130 | Insert |
|------|-------------|--------|



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number Description Batch

54 ALS4-1032-130 Inserts M18293
or (see QSI 017)

(54)

FC 06 03 22

| | | |
|------|------------|--------|
| 24.0 | AN960JD10L | Washer |
|------|------------|--------|



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number Description Batch

54 AN960JD10L Washer M19186

(54)

9. m 06-03-22

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24764

Part Number: D206642341

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|------------|-------|
| 25.0 | MS27039108 | Screw |
|------|------------|-------|



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|--------|
| 54 | MS27039-1-08 | Screw | M16741 |

(54)

| | | |
|------|--------|------|
| 26.0 | D26511 | Plug |
|------|--------|------|



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 14 | D2651-1 | Plugs | B26010 |

(14)

| | | |
|------|--------|--------|
| 27.0 | D26513 | O-Ring |
|------|--------|--------|



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 14 | D2651-3 | O-Rings | B23491 |

(14)

| | | |
|------|------------|--------|
| 28.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | AN960JD416 | Washer | M11151 |

(1)

| | | |
|------|------------|-------|
| 29.0 | MS27039406 | Screw |
|------|------------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|--------------|-------------|--------|
| 1 | MS27039-4-06 | Screw | M15194 |

(1)

9. m 06-03-22

Date: Monday, 11/14/2005 2:28:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24764

Part Number: D206642341

Job Number:



Seq. #: Machine Or Operation: Description :

30.0 D2646 Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap 022507

①

31.0 AN960JD10L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer M19185

②

32.0 MS27039108 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw M10941

A - m 06-03-22

②

33.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M19597

Sikaflex expiry date:

06-15-06

a - m 06-03-22

①

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M19597

Sikaflex expiry date:

06-15-06

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M100037

FC 06 03 22

Date: Monday, 11/14/2005 2:28:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 24764

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

W DC 06/03/23

(1)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Package per PFP

DEV.E

06/03/23 (1)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/24 (1)

Job Completion



u 06-03-24

□□□□□□□□

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 14, 2005
02:29 pm

Work Order No : 0024764
Project Name : D206-642-341
Project For : WK548
Work Order Type : Main
Main WO Number :
House Part Number : *D206-642-341
Description : Replacement Skidtube
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 11-14-05
Est Finish Date : 11-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

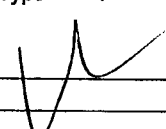
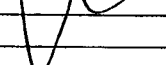
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Margin : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |

Date: Thursday, 11/10/2007 2:26:44 PM
 User: Linda Lacelle

Process Sheet

| | |
|---|---------------------------------------|
| Customer : CC-DAR01 Dart Aerospace Ltd. | Drawing Name : D206-642 |
| Job Number : 35132 | |
| Estimate Number : 10804 | |
| P.O. Number : | Part Number : Z_CUSTOM |
| This Issue : 11/10/2007 S.O. No. : | Drawing Number : ECN 1046-PAPERWORK |
| Prsht Rev. : NC | Project Number : |
| First Issue : // Type : LANDING GEAR | Drawing Revision : |
| Previous Run : 00015 | Material : |
| Written By :  | Due Date : 18/10/2007 Qty: 1 Um: Each |
| Checked & Approved By :  | |
| Comment : | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STOCK:

D206-642-111 15614 15615
 D206-642-112 10319 25504
 D206-642-141 9075 18613
 D206-642-211 33078 32559-32565-33795-33776
 D206-642-212 32257 32567-32566-32568-33079-33080-33242
 D206-642-213 19735
 D206-642-214 24414-24484-28083-29084-32983-32984
 D206-642-241 28097-28604-33211-33342
 D206-642-311 28847
 D206-642-312 29741-15619-29742-29744
 D206-642-341 29741-15619-29742-29744
 D206-642-411 34555-34056-34555-34556-32495-31980
 D206-642-411BL 34132
 D206-642-412 34564-34563-34562-34060-34059-32502-34058
 D206-642-412BL 34735
 D206-642-441 31066-30940-30260-30265-24739
 D206-642-511 34582-34579-33848-34581
 D206-642-512 34586-34584-34583-
 D206-642-513
 D206-642-514
 D206-642-541
 D206-642-611
 D206-642-612

ADD NEW PAPERWORK EASA.IM.R.S.01320 REV.1
 PER ECN 1046

1-11-07 SP